



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2604-2

Job Sheet 171008



Part No: D2604-2

Job Qty: 4 ea

Part Name: Console Side RH, 407 Console



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/25/18

Job Tracking No:

Due Date: 2/16/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP D 02.06.05 Added alodine finish TSR 1290 NG IPP Rev:D 07-09-24 Now On Waterjet JLM
Verified By:EC IPP Rev:E 07-12-18 RevB as per dwg ECN1059 DD verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	2/15/18	2/15/18	0.00	0.00	Start Up Waterjet		pc 18/01/29
100	Waterjet	4 pcs	2/15/18	2/15/18	0.00	0.51	Waterjet1		pc 18/01/29
110	QC	4 pcs	2/15/18	2/15/18	0.00	0.00	QC2 Waterjet-1		pc 18/01/29
120	QC	4 pcs	2/15/18	2/15/18	0.00	0.00	QC8-1		38
130	Brake NC	4 pcs	2/15/18	2/15/18	0.00	0.37	Brake NC 2		DAS 9-88 SB
140	QC	4 pcs	2/15/18	2/15/18	0.00	0.00	QC5		38
150	HandFinish	4 pcs	2/16/18	2/16/18	0.00	0.34	HandFinish1		18-02-07 9-88
160	QC	4 pcs	2/16/18	2/16/18	0.00	0.00	QC3 Q67		38
170	Packaging	4 pcs	2/16/18	2/16/18	0.00	0.00	Packaging3-1	5482	9-88 821
180	QC21-SA	4 Ea	2/16/18	2/16/18	0.00	0.00	QC21		

Part Op **100** - 1-Cut as per Dwg D2604 Dwg Rev: B Prog Rev: B 2-Deburr if necessary
Descriptions: **130** - Deburr if necessary Form as per Dwg D2604

DAS
21
9-88
FEB 12 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	5.3888 sf (1.3472 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	5	96	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Water Jet ☐ Engineering ☐ Drilling ☐ Quality ☐ Milling ☐ Other ☐																																																																					
Date : _____		Step #: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																					
Description Work Order Deviation																																																																									
Root Cause		<table border="0"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> <table border="0"> <tr><td>Pressure/Forced</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td></tr> </table>				Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐
Environment	☐	No Re-verification	☐																																																																						
Design	☐	Operator	☐																																																																						
Doc/Data	☐	Offset/Setup	☐																																																																						
Equip/Tooling	☐	Supplier	☐																																																																						
Handling/Pre	☐	Training	☐																																																																						
Material	☐	Use for Testing	☐																																																																						
Internal Transport	☐	Poor Information	☐																																																																						
Tribal Knowledge	☐	Rushing	☐																																																																						
LOA	☐	Product Improvement	☐																																																																						
Substation	☐	Process Improvement	☐																																																																						
Past Expiry Date	☐	Manufacturing Process	☐																																																																						
Misidentified	☐	Past Due	☐																																																																						
Pressure/Forced	☐																																																																								
Bending	☐																																																																								
Centre Not Concentric	☐																																																																								
Cracks	☐																																																																								
Crimp/Kink/Ripple/Wave	☐																																																																								
Cuffs	☐																																																																								
Crushing	☐																																																																								
Heat Treat	☐																																																																								
Wave/Twist in Tube	☐																																																																								
Marks/Chatter	☐																																																																								
OTHER : _____																																																																									

DART
AEROSPACE
S037710



Console Side RH, 407 Console

PART NO: D2604-2
 Original Serial #: S037710
 Revision:
 Operation:
 Change No:

Start up Operation 02/01/18

Job No: 171008

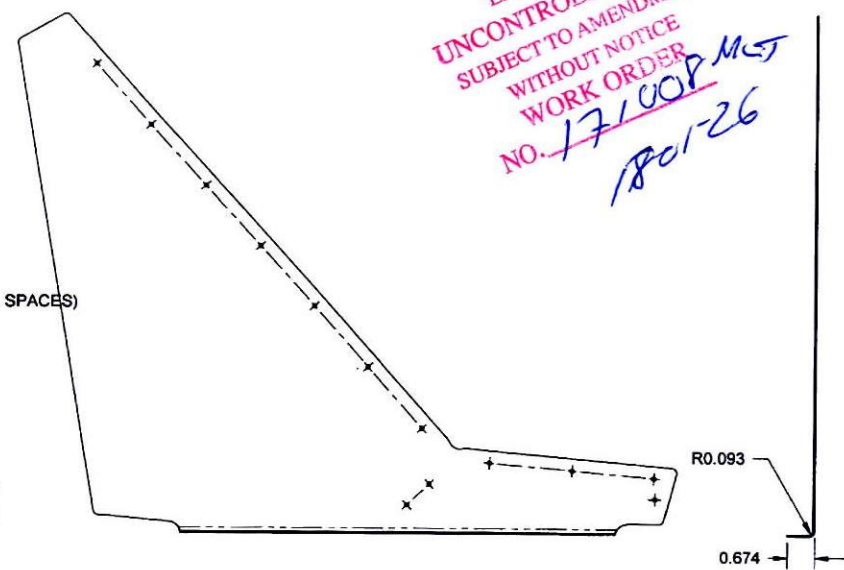
MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

- ☐ Positioned Wrong
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Drawing
- ☐ Finish
- ☐ Misread
- ☐ Turning Sequence



D2604-1F FLAT PATTERN

—BEND LINE

RELEASED
07-12-12

B	ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES	DC	07.11.07
A	D2604 WAS D206-547-231-24	BW	97.10.24
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.		D2604	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CONSOLE SIDE	1:3
DATE	07.11.07	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED TO THE EXPRESS CONSENT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:
 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037
 (REF DART SPEC M2024T3S.040)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.36 lbs